

Plastic-Bond



Excellent adhesion to plastics | high strength | shock- and impact-resistant

WEICON Plastic-Bond is a solvent-free structural adhesive with very good adhesion to plastics, aluminum, steel and many other materials. The adhesive is suitable for static as well as dynamic loads, has high impact and peel strength and a maximum gap-filling capacity of 5 mm.

Plastic-Bond is particularly convenient for structural bondings if high-strength connections are required. The adhesive is highly viscous and is therefore suitable for processing on vertical surfaces.

The structural adhesive is universally applicable and can be used, for example, in plastics technology, in metal construction, in car body and vehicle construction, in mechanical engineering, in electrical engineering, in wood processing, or in trade show and exhibition construction.

Characteristics

Base	methyl methacrylate
Texture	viscous
Colour	off-white, milky

Processing

Processing temperature	+10°C to +40°C
Cure temperature	+18 °C
Mixing ratio by weight	1:1
Viscosity of the mixture	40.000-60.000 mPa·s
Density of the mixture	0,98-1,02 g/cm ³
Gap bridging up to max.	5 mm

Curing

Pot life	at 20 °C	15 min.
Handling strength	(35 % strength)	40 min.
Working strength after	(50 % strength)	60 min.
Final strength	(100 % strength)	12 h

Note

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Mechanical properties after curing

Lap shear strength material thic kn. 1,5mm DIN EN 1465	
Steel 1.0338 sandblasted	23 N/mm ²
Stainless steel V2A sandblasted	22 N/mm ²
Aluminium sandblasted	20 N/mm ²
PVC-rigid roughened	12 N/mm ²
CFRP	22 N/mm ²
ABS	7 N/mm ²
PC (polycarbonate)	11 N/mm ²
GFRP	21 N/mm ²
PMMA	9 N/mm ²
Polyamide 6.6	1 N/mm ²

Thermal parameters

Temperature resistance	-55°C to +125°C
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Electrical parameters

Dielectric strength	DIN EN 60243-1 (20°C)	21 kV/mm
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Approvals / Guidelines

IMPA Code	812993
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Instructions for use

When using WEICON products, the physical, safety-related, toxicological and ecological data and regulations in our EC safety data sheets (www.weicon.com) must be observed.

Surface pre-treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner). Best results are achieved when the adhesive surfaces are mechanically roughened. The adhesive is applied to just one side.

Processing

Plastic-Bond can be processed straight from the double cartridge by means of the included static mixer. Dismiss the first 5 cm of the adhesive bead. The adhesive is applied to just one side. The specified pot life refers to a material batch of 10 ml at room temperature. Larger batch quantities will result in faster curing. Higher temperatures also reduce the pot life and curing time. (General rule: every increase by +10 °C above room temperature results in a decrease of the pot life and curing time by half). Temperatures below +16 °C increase the pot life and curing time significantly. From approx. +5C and below, no reaction takes place.

Storage

Shelf life of 12 months when unopened and stored in normal climate (+23°C and 50 % rel. air humidity).

Scope of delivery

Adhesive

Plastic-Bond

Accessories

- 10005237 Dispenser Easy-Mix D 50, 1 PCE
- 10005236 Quadro Mixing Nozzle A, 1 PCE
- 10026925 Helix Mixing Nozzle A, 1 PCE
- 10068261 Dosing Tip, 1 PCE

Conversion table

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$	$\text{Nm} \times 8.851 = \text{lb}\cdot\text{in}$
$\text{mm}/25.4 = \text{inch}$	$\text{Nm} \times 0.738 = \text{lb}\cdot\text{ft}$
$\mu\text{m}/25.4 = \text{mil}$	$\text{Nm} \times 141.62 = \text{oz}\cdot\text{in}$
$\text{N} \times 0.225 = \text{lb}$	$\text{mPa}\cdot\text{s} = \text{cP}$
$\text{N}/\text{mm}^2 \times 145 = \text{psi}$	$\text{N}/\text{cm} \times 0.571 = \text{lb}/\text{in}$
$\text{MPa} \times 145 = \text{psi}$	$\text{kV}/\text{mm} \times 25.4 = \text{V}/\text{mil}$

Available sizes

- 10018558 Plastic-Bond, 24 ml, off-white, milky
- 10058780 Plastic-Bond, 1 Set, off-white, milky

To the product detail page:



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